

**Work Order ID 59388**

Thursday, June 03, 2010 11:22:45 AM

Page 1

Item ID: D315-668-011

Accept

Revision ID:

Item Name: Skidtube LH

Start Date: 6/3/2010 Start Qty: 1.00

Required Date: 6/14/2010 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: PH Date: 10-6-03 Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2904

Rev B

100

0.00



DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile &amp; type labels per PPPD315-668-011

CHG 001

8/10/08/30

HJ for BG 10/07/28

B59388

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

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Reference:

Run

Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110



Skidtubes

Skidtubes

0.00

Skidtubes

Memo

0.00

LANDING GEAR RESOURCE 1

1-Cut D2904b to length as per dwg D2904

2-Drill aft and fwd cap holes as per dwg D2904 using DT8025 jig  
(DO NOT OPEN TO FINISH SIZE)3-Drill saddle holes (6 Deg) as per Dwg D2904 using DT8938A jig  
(ENSURE THAT LOCATOR RING IS SET FOR LH TUBE)4-Drill GHW holes (3 Deg) as per Dwg D2904 using DT8938B jig  
(ENSURE THAT LOCATOR RING IS SET FOR LH TUBE)5-Insert and cleco doublers and DT8938d in position. Transfer all 256 holes thru  
tube and doublers.

6-Remove doublers and identify batch# and orientation

7-C'sink Rivet holes 256 places as per Dwg D2904 and deburr

8-Locate from saddle holes, drill wearplate holes using DT8994. Jig must be 1.7"  
from aft end of tube (REF)9-Remove fwd and aft indexing ridges as per dwg D2904. Open fwd and aft cap  
holes to finish size, scribe batch# at aft end of tube.

10-Remove marks left from drill jig and deburr

DP 10-6-7

M 10/6/10

DP 10-6-8

DP 10-7-12

M 10/6/10

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run

Start



Stop



Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/10/07/12

Quality Control

40

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

DP

10-7-12

Hand Finishing

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 M 10-7-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



Skidtubes

Skidtubes

0.00

0.00

Memo

LANDING GEAR RESOURCE 1

1-Remove alodine around X-Bolt holes on doublers

2-Rivet doublers as per Dwg D2904.(DO NOT INSTALL RIVETS AROUND X-BOLT HOLES AT THIS TIME)

3-Open X-Bolt spacer holes to finish size as per dwg D2904.(DO NOT USE CUTTING FLUID)

4-C'sink and deburr X-Bolt spacer holes, prepare for Welding.

5-Blow all chips from inside tube

6-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting Pick:

Qty ☐ Part Number ☐ Description ☐ Batch  
A/R ☐ ☐ Sikaflex-291 ☐ M113519 ☐

Sikaflex expire date: 10-11-30

Start Time: 10AM Date: 10-7-14

Fin Time: Date:

10-7-14

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Dart Aerospace Ltd

W/O: 59388		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10.06.09	110	USE CR3212-403 RIVETS B/N 1114859 (256) INSTEAD OF MS20601 AD463 FSHARR = 240 <sup>16</sup> FOR MS20601 FSHARR = 664 <sup>16</sup> FOR CR3212	BE	10/07/20		CP 10.06.09 QSA 642	S 10/07/20	

Part No: D315-668-011 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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10/06/09	110							

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Start Date: 6/3/2010 Start Qty: 1.00

Required Date: 6/14/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

0.00



Skidtubes

Skidtubes

Memo

0.00

LANDING GEAR RESOURCE 1

1-Weld crossbolt spacers D2909as per Dwg. D2904and QSI 004.  
For D2579 spacers, weld one side, pass Y" drill, weld other side, pass Y" drill  
A/R□□□ Aluminum Rod *M112507*

2-Grind welds as per Dwg D2909

3-Install remaining rivets arround X-Bolt spacer , use rivet shaver as necessary

4-Deburr,inspect tube for any visible scratches

*BE 10/07/20**3 BE 10/07/20*

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

*S 10/02/20*

Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D315-668-011

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Setup

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Revision ID:

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Item Name: Skidtube LH

Start Date: 6/3/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Run

Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:35.  
220°  
2:05

40

1 BR 10-7-22

1 BR 10-7-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D315-668-011

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Setup Start



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Stop



Item Name: Skidtube LH

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Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

QC3- Inspect Part Finish

0.00

=) JH 10/07/27



QC

Memo

0.00

Quality Control

220

HandFinishing

0.00

=) JH 10/07/27



HandFinish

Memo

0.00

Hand Finishing

HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2904. Use a drop of Sikaflex on

insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☐ M115028

Sikaflex expire date: 11/01

3-Inspect for foreign object per QSI 024

4-Install 2646 Aft & fwd Caps as per Dwg D2904 and seal with Sikaflex. Clean

excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ M115028

Sikaflex expire date: 11/01

5-Wing Walk as per Dwg D2904 and QSI 005

4.4

Batch: M115028

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item Name: Skidtube LH

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Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Run

Start



Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

230



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 10/07/27

⑩

240



Packaging

Packaging

Identify as per dwg &amp; Stock Location: 80

0.00

Memo

0.00

REVA

10/7/30

250



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/08/03

MF 10-8-03



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# Picklist Print

Thursday, June 03, 2010 11:22:50 AM

Page 1

Work Order ID: 59388

Parent Item: D315-668-011

Parent Item Name: Skidtube LH

Comments: IPP Rev:A New Issue 07-04-12 JLM  
IPP Rev:B remove seq. 19 (handfinish wing walk) 08-04-30 DD verified by:EC

Start Date: 6/3/2010

Start Qty: 1.00

Required Date: 6/14/2010

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
D2904B		Manufactured	No			110	Each	9.0000	1	1			
Skidtube, 315													

Location	Loc Qty
LG	9
31828	1
36926	1
57330	7

359525 ①

Loc Code

10-6-7

D2910		Manufactured	No			110	Each	26.0000	2	2			
Doubler													

Location	Loc Qty
ST030	26
36927	26

Loc Code

2 11/2/6/8

D2911		Manufactured	No			110	Each	35.0000	2	2			
Doubler													

Location	Loc Qty
ST030	35
36928	35

Loc Code

2 11/2/6/8

MS27039-1-08		Purchased	No			110	Each	1,501.000	54	54			
Screw													

Location	Loc Qty
ST291	1501
110552	44
110835	1257
114718	200

Loc Code

854 10/07/27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

**Work Order ID:** 59388

**Parent Item:** D315-668-011

**Parent Item Name:** Skidtube LH

**Comments:** IPP Rev:A New Issue 07-04-12 JLM  
IPP Rev:B remove seq. 19 (handfinish wing walk) 08-04-30 DD verified  
by:EC

**Start Date:** 6/3/2010**Required Date:** 6/14/2010

**Start Qty: 1.00**

**Required Qty: 1.00**

[illegible]

Thursday, June 03, 2010 11:22:50 AM

## Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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IPP Rev:B remove seq. 19 (handfinish wing walk) 08-04-30 DD verified by:EC

Start Date: 6/3/2010

Start Qty: 1.00

Required Date: 6/14/2010

Required Qty: 1.00

Component Item ID/ ALS4-1032-130	Replacement	Mfg/ Purchased	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
			No			220	Each	5,999.000	50	50			

Insert

## Location

## Loc Qty

## Loc Code

PKG11

5000

(14723)

5000

ST282

390

110511

38

114407

352

ST381

609

114654

609

AN960JD10L

NAS1149D0332J

Purchased

No

220

Each

3,878.000

54

54



Washer

## Location

## Loc Qty

## Loc Code

ST348

3878

(110985)

3878

D2646

Manufactured

No

220

Each

109.0000

2

2



Aft Cap

## Location

## Loc Qty

## Loc Code

FP-4

99

(57332)

99

FP6

10

52663

10

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Shop Packet Print

Page 3

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Comments: IPP Rev:A New Issue 07-04-12 JLM  
IPP Rev:B remove seq. 19 (handfinish wing walk) 08-04-30 DD verified by:EC

Start Date: 6/3/2010

Required Date: 6/14/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D2648-3	Replacement	Mfg/ Manufactured	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date • Status
			No			220	Each	13.0000	5	5		
Wearpad												
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
				FG			12					
				45316			12					
				FP17			1					
				52516			1					
D2656-13		Manufactured	No			220	Each	24.0000	1	1		
												
Wearplate												
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
				FP020			12					
				57354			12					
				FP20			12					
				55454			12					
D2656-33		Manufactured	No			220	Each	19.0000	1	1		
												
Wearplate												
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
				MEZZ			19					
				43806			6					
				46167			13					

X 5 M 10/6/20

X 1 M 10/07/27

X 1 M 10/07/27

Thursday, June 03, 2010 11:22:50 AM

Shop Packet Print

Page 4



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 5

Work Order ID: 59388



Parent Item: D315-668-011



Parent Item Name: Skidtube LH

Comments: IPP Rev:A New Issue 07-04-12 JLM  
IPP Rev:B remove seq. 19 (handfinish wing walk) 08-04-30 DD verified  
by:EC

Start Date: 6/3/2010

Required Date: 6/14/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D2907	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 220	Unit of Each	Qty on 29.0000	Qty per Kit 1	Total 1	Qty	Date	Status
Wearshoe													

## Location

## Loc Qty

## Loc Code

FP 29

14654 29

220 Each

30.0000 11

YI : M 10/07/22

D2909



Spacer, Lama

Manufactured No

## Location

## Loc Qty

## Loc Code

LG 30

14091 30

B 59594

10/11

BE 10/07/20

Thursday, June 03, 2010 11:22:50 AM

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2904	Rev. B SHEET 1 OF 3
DATE 00.06.21		TITLE SA 315B SKIDTUBE ASSEMBLY	SCALE NTS
A	99.09.09	NEW ISSUE	
B	00.06.21	CHANGED ANGLES FOR HOLES	

PARTS LIST:

Qty -041	Qty -042	Part Number	Description
X		D2904-041	LH SKIDTUBE ASSEMBLY
	X	D2904-042	RH SKIDTUBE ASSEMBLY
2	2	D2646	CAP
4	4	D2648-3	WEARPAD
1	1	D2648-5	WEARPAD
1	1	D2656-13	WEARSHOE
1	1	D2656-33	WEARSHOE
1		D2904-1	SKIDTUBE
	1	D2904-2	SKIDTUBE
1	1	D2905	WEB
1	1	D2907	WEARSHOE
11	11	D2909	CROSS BOLT SPACER
2	2	D2910	SKIDTUBE DOUBLER
2	2	D2911	SKIDTUBE DOUBLER
2	2	D2912	SKIDTUBE DOUBLER
50	50	ALS7-1032-130 -or AKS4-1032-130 or ALS4-1032-130 or ALS7-1032-130	INSERT
54	54	AN960JD10L	WASHER
256	256	MS20601AD4W3	RIVET
54	54	MS27039-1-08	SCREW

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WITHOUT NOTICE  
WORK ORDER  
NO. 59388

2810-6-03

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00.07.01

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**NOTE:** Date & initial all entries



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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2904	Rev. B SHEET 2 OF 3
DATE 00.06.21		TITLE SA 315B SKIDTUBE ASSEMBLY	SCALE 1:20

**GENERAL NOTES:**

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. MAKE D2904-1 AND D2904-2 FROM D2914 EXTRUSION (INITIAL LENGTH = 142.0).
3. DAMAGE TOLERANCE ON BENDING:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
4. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTION C-C.
5. DRILL #30 HOLES ( $\varnothing 0.128$  REF) TO LINE UP WITH  $\varnothing 0.128$  HOLES IN D2910/D2911/D2912 DOUBLERS. C'SINK  $\varnothing 0.239 \times 100^\circ$ .
6. BOND D2905 WEB INTO D2904-1 (OR D2904-2) OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
7. WELDING TO BE DONE PER DART QSI 004.
8. AFTER DRILLING, BENDING, AND INSTALLING WEB & DOUBLERS, PERFORM THE FOLLOWING FOR  $\varnothing 0.500$  HOLES ONLY:
  - CHAMFER HOLE  $0.050 \times 45^\circ$
  - INSERT D2909 SPACER (11 PLACES)
  - WELD INTO PLACE
  - GRIND FLUSH
  - DRILL OUT SPACER TO  $\varnothing 0.406$
9. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
  - MINIMUM YIELD TENSILE STRENGTH = 35 ksi
  - MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
10. FINISH:
  - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2905 WEB AND D2910/D2911/D2912 DOUBLERS.
  - POWDER COAT WHITE (REF. 4:3:5:1) PER DART QSI 005 4.3
  - BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
11. DRILL  $\varnothing 0.297$  FOR ALS7-1032-130 INSERT USING DT8395 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH.

*w/o 59388*

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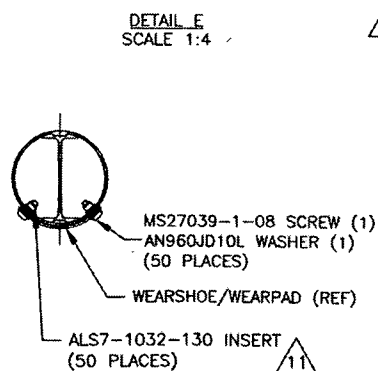
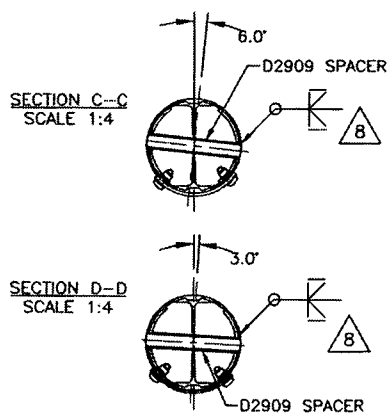
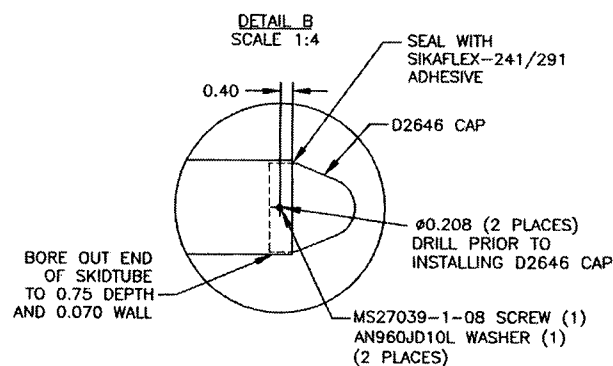
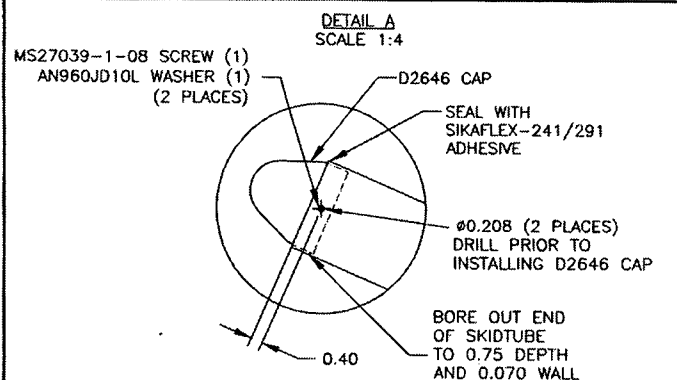
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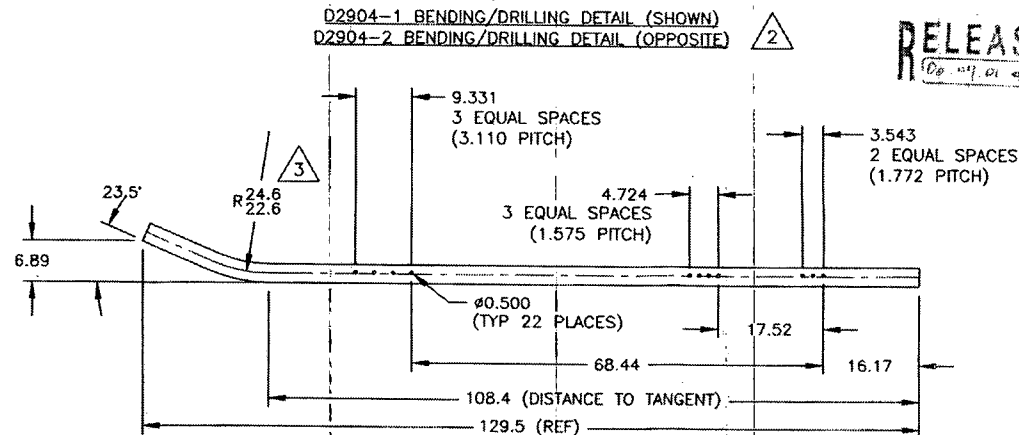
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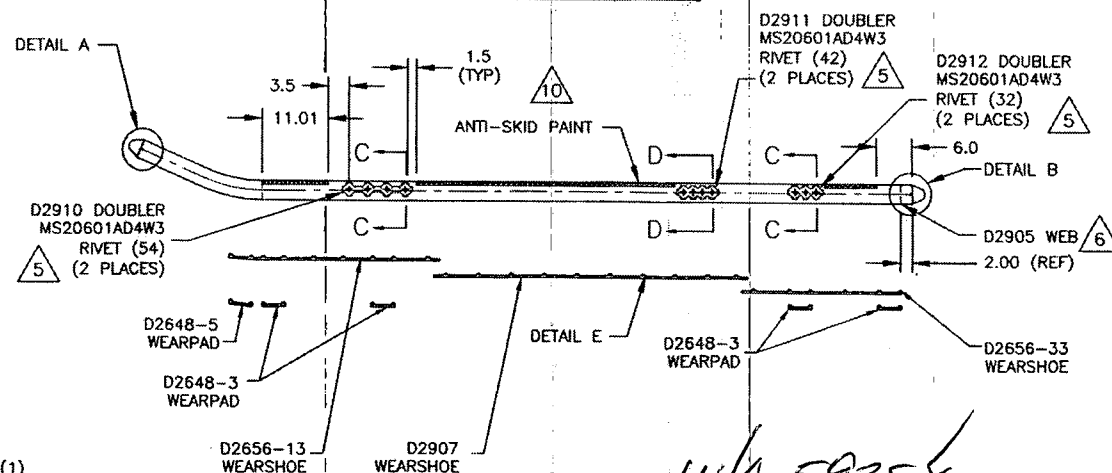
**NOTE:** Date & initial all entries



D2904-1 BENDING/DRILLING DETAIL (SHOWN)  
D2904-2 BENDING/DRILLING DETAIL (OPPOSITE)



D2904-041 LH ASSEMBLY DETAIL (SHOWN)  
D2904-042 RH ASSEMBLY (OPPOSITE)



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		DATE	00.06.21	TITLE		SA 315B SKIDTUBE ASSEMBLY	SCALE 1:20



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NO. 231

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 573263  
Part number: D315 668 012  
Description: Lama tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat. Dent. Date of Test Coupon 10.05.18

Welder Barclay Elliott Date of Test Coupon 10.05.18

The above named individual is qualified in accordance with AWS D17.1.2001 to weld